

Work Order ID 69681

Monday, May 16, 2011 10:40:57 AM



Page 1

Ship today

Item ID: D350-636-047

Accept



Setup Start



Revision ID:

Stop



Item Name: Training Wearplates Installation, LH/RH

Start Date: 5/16/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *MF*Date: *11-05-16*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN-D350-636

H U/R

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-636-047 CHG002

*(PARTS ARE RUSHED)**8/11/16**MF 11-05-16*

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

Pick 5/16/16

115

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

*8/11/16**(X2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D350-636-047

Accept



Setup Start



Revision ID:

Stop



Item Name: Training Wearplates Installation, LH/RH

Start Date: 5/16/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-636-047

Location: _____

PPP Rev: _____

130

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

ME

11-05-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, May 16, 2011 10:40:54 AM

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Work Order ID: 69681

Parent Item: D350-636-047

Parent Item Name: Training Wearplates Installation, LH/RH

Start Date: 5/16/2011

Required Date: 5/16/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 10.09.27 NEW ISSUE DD VERF:EC [PP
Rev:B 11.04.14 ecn11-553 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
S72 D4154-041 Wearplate Assembly		Manufactured	No			110	Each	0.0000	1	2			
										6F297			
S72 AN3C36A BOLT		Purchased	No			110	Each	181.0000	4	8			

Location	Loc Qty	Loc Code
FG	14	
101261	4	
116590	10	116590
FP-B	47	
111925	47	
ST303	20	
116590	20	
ST353	100	
117125	100	

S72 AN3C37A BOLT		Purchased	No			110	Each	89.0000	1	12			
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Location	Loc Qty	Loc Code
ST353	13	
116874	11	
117010	2	
ST354	76	
117343	76	117343

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, May 16, 2011 10:40:54 AM

Page 2

Work Order ID: 69681

Parent Item: D350-636-047

Parent Item Name: Training Wearplates Installation, LH/RH

Start Date: 5/16/2011

Required Date: 5/16/2011

Start Qty: 2.00

Required Qty: 2.00

SFL	AN3C42A	Purchased	No	110	Each	44.0000	1	2	
	BOLT								
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
				ST354	44				
				106176	44				
SFL	NAS1149C0363R	Purchased	No	110	Each	4,696.000	10		
	Washer								
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
				ST297	4696				
				113889	81				
				114742	4615				
SFL	MS21043-3	Purchased	No	110	Each	732.0000	5		
	Nut								
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
				FG	80				
				103691	80				
				ST301	652				
				112314	652				
SFL	D3873-1	Manufactured	No	110	Each	123.0000	8		
	Bushing								
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
				ST088	123				
				62197	12				
				63314	2				
				64567	9				
				64760	100				

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, May 16, 2011 10:40:55 AM

Work Order ID: 69681

Parent Item: D350-636-047

Parent Item Name: Training Wearplates Installation, LH/RH

Start Date: 5/16/2011

Required Date: 5/16/2011

Start Qty: 2.00

Required Qty: 2.00

D4171-1 Manufactured No

110 Each

29.0000

1

2



Bushing

Location

Loc Qty

Loc Code

ST135

29

65646

8

69037

21

65646

D4170-1 Manufactured No

110 Each

30.0000

4

8



Bushing

Location

Loc Qty

Loc Code

LG

26

61581

5

68225

21

LG002

4

65912

4

6F200

AN3C34A Purchased No

110 Each

33.0000

1

2



BOLT

Location

Loc Qty

Loc Code

ST352

20

117514

20

ST353

13

116003

13

116003

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

8.0 PARTS LIST (D350-636-015/-016/-017/-018/-047 KITS)

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -047	Part Number	Description
	X					D350-636-015	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE W/ TRAINING WEARPLATE
		X				D350-636-016	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE W/ TRAINING WEARPLATE
			X			D350-636-017	SKIDTUBE INSTALLATION, LH AIRCRAUSER/ APICAL TRI-BAG FLOAT COMPATIBLE W/ TRAINING WEARPLATE
				X		D350-636-018	SKIDTUBE INSTALLATION, RH AIRCRAUSER/ APICAL TRI-BAG FLOAT COMPATIBLE W/ TRAINING WEARPLATE
					X	D350-636-047	TRAINING WEARPLATE KIT (LH/RH)
1	1					D4168-041	SKIDTUBE ASSEMBLY, LH
1		1				D4168-042	SKIDTUBE ASSEMBLY, RH
1			1			D4168-043	SKIDTUBE ASSEMBLY, LH
1				1		D4168-044	SKIDTUBE ASSEMBLY, RH
*1	1					D4168-1	SKIDTUBE WELDMENT, LH
*1		1				D4168-2	SKIDTUBE WELDMENT, RH
*1			1			D4168-3	SKIDTUBE WELDMENT, LH
*1				1		D4168-4	SKIDTUBE WELDMENT, RH
**2	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8		22541N120	NUT
*5	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1		AN960C816L	WASHER (OR NAS1149CO832R)
*7	1	1	1	1		MS21083C8	NUT
*8	1		1			D3488-041	BLADE FITTING, LH
*8		1		1		D3488-042	BLADE FITTING, RH
9	1	1	1	1		D2741	BLADE
10	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2		AN960JD816	WASHER (OR NAS1149CO863J)
12	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8		D2745	BUSHING
*16	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4		AN960C10L	WASHER (OR NAS1149CO332R)
*20B	4	4	4	4		NAS1515H3L	WASHER
*30	8	8	8	8		D3492-041	PLUG ASSEMBLY
*31	8	8				D3492-043	PLUG ASSEMBLY
*32			8	8		D3492-045	PLUG ASSEMBLY

(CONTINUED ON NEXT PAGE)

(CONTINUED FROM PREVIOUS PAGE)

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -047	Part Number	Description
***43	2	2	2	2		D3493-1	WASHER
*90	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
*91A	4	4	4	4	4	AN3C36A	BOLT ¹
91B	1	1	1	1	1	AN3C37A	BOLT ²
91C	1	1	1	1	1	AN3C42A	BOLT ³
*92	7	7	7	7	8	AN960C10	WASHER (OR NAS1149CO363R)
92A			1	1		AN960C10	WASHER (OR NAS1149CO363R) ³
*93	4	4	4	4	4	MS21043-3	NUT
*94	7	7	7	7	8	D3873-1	BUSHING
94A			1	1		D3873-1	BUSHING ³
*95	1	1	1	1	1	D4171-1	BUSHING ⁴
*96	4	4	4	4	4	D4170-1	SPACER
*97	1	1	1	1	1	AN3C34A	BOLT
*98	2	2	2	2	2	AN960C10	WASHER (OR NAS1149CO363R)
*99	1	1	1	1	1	MS21043-3	NUT

* PART OF D4168-041/-042/-043/-044

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING AN APICAL FLOAT SYSTEM

¹ QTY USED MAY BE LESS ON SKIDTUBES WITH APICAL CYLINDRICAL OR TRI-BAG FLOATS² HARDWARE USED ON THE SKIDTUBES INSTALLED WITH APICAL CYLINDRICAL BAG FLOATS³ HARDWARE USED ON THE SKIDTUBES INSTALLED WITH APICAL TRI-BAG FLOATS⁴ HARDWARE NOT USED ON THE SKIDTUBES INSTALLED WITH APICAL TRI-BAG FLOATS

Under Review Notification

Raised By: M. BELLAVANCE

Date: 10.10.25

Product #: D350-636-047

Product Name: TRAINING WEARPLATE KIT

Drawing/Kit Number	Drawing/Kit Description	Quantity on Hand (Stock)	Quantity on Order (Production)	Quantity Allocated (Customer Order)	HOLD SHIPMENT	Red Tag/Quarantine Stock	Advise customers	Stop Production	Re-Work Stock	IPP Under Review	Blue File Under Review	ECN #	Instructions
D350-636-047	TRAINING WEARPLATE KIT				Y	Y	Y	N	Y	Y	Y		D4170-1 TO BE REPLACED BY D4170-3
													A DSI WILL BE CREATED TO SUPPORT
													THE CHANGE.
													NEED TO SOURCE FOLLOWING STOCK
													ASAP: 6061-T6 TUBING, 0.438 O.D.
													BY 0.058 WALL.

Description of issue:

ERA REPORTED THAT THEY CAN'T RETROFIT THEIR EXISTING SKIDTUBE AND INSTALL THE D350-636-047 KIT BECAUSE:

- 1) INSTRUCTIONS TO DRILL SKIDTUBE FOR INSTALLATION OF D4170-1 BUSHINGS ARE NOT ADEQUATE (HOLE SIZE SMALLER THAN BUSHING).
 - 2) THE D3873-1 AND D4171-1 BUSHINGS CAN'T BE INSTALLED INTO D4170-1 BUSHING: I.D. OF D4170-1 IS TOO SMALL.
- REF. NCR10-372 AND SQ10199.

Distribution:

General Manager
Production Manager
Director Quality Assurance
Design Manager
Chief Engineer

Production Engineering Coordinators
Quality Assurance Coordinator
Quality Control Coordinator
Order Processing
Customer Technical Support

Engineering Project Managers
Engineering Clerk
Marketing

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Shipment	D350-636-047 / Training Wearplates Installation, LH/RH	Main Warehouse	SO103330	BEDF01		3.0000		3.0000		
		FG			10/13/2010	-1.0000	62571	-1.0000		(\$522.53)
		Main Warehouse	SO103331	BEDF01		2.0000		2.0000		
		FG			10/13/2010	-1.0000	62571	-1.0000		(\$522.53)
		Main Warehouse	SO103405	BEDF01		3.0000		2.0000		
		FG062			11/8/2010	-2.0000	63191	-2.0000		(\$1,045.06)
		Main Warehouse	SO103863	BEDF01		2.0000		1.0000		
		FG062			12/23/2010	-1.0000	64919	-1.0000		(\$522.53)
		Main Warehouse	SO103863	BEDF01		1.0000		1.0000		
		FG062			12/23/2010	-1.0000	64894	-1.0000		(\$522.53)
WIP Receipt	D350-636-047 / Training Wearplates Installation, LH/RH	Main Warehouse	62571	LACE01		0.0000		0.0000		
		FG			10/13/2010	3.0000	62571	3.0000		\$1,567.59
		Main Warehouse	63191	FAUT01		1.0000		0.0000		
		FG062			11/8/2010	1.0000	63191	1.0000		\$522.53
		Main Warehouse	63191	FAUT01		2.0000		1.0000		
		FG062			11/8/2010	1.0000	63191	1.0000		\$522.53
		Main Warehouse	64919	FAUT01		0.0000		0.0000		
		FG062			12/23/2010	1.0000	64919	1.0000		\$522.53
		Main Warehouse	64894	FAUT01		1.0000		0.0000		
		FG062			12/23/2010	1.0000	64894	1.0000		\$522.53
		Main Warehouse	65910	FAUT01		0.0000		0.0000		
		FG062			2/16/2011	2.0000	65910	2.0000		\$1,045.06
								0.0000		-8.0000

U/R AS OF
OCT. 25 / 2010

OK TO SHIP PER MB 10.11.08

COFC only PER MB 10.12.23

CHUCK @ ERA

PRELIM

COFC only PER MB 10.12

CHUCK @ ERA

TEST FIT

ERA

U/R AS OF
OCT. 25/2010

OK TO SHIP PER MB 10.11.08
COFC only PER MB 10.12.23
CHUCK @ ERA
CHUCK only PER MB 10.12.23
CHUCK @ ERA FOR TEST FIT
ERA

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date	Extended Cost
WIP Receipt	D350-636-047 / Training Wearplates Installation, LH/RH	Main Warehouse	69681	FAUT01		0.0000		0.0000		
		FG062			5/16/2011	2.0000	69681	2.0000		\$1,045.06
								11.0000		\$5,747.84

Location/Lot Activity

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Criteria :	All Items	All Locations	Lot: 65910	All Transaction Types	All Dates	Report on Locations & Lots				
Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Rework	D350-636-047 / Training Wearplates Installation, LH/RH	Main Warehouse	67916	FAUT01		2.0000		2.0000		
		FG062			4/4/2011	-2.0000	65910	-2.0000		(\$1,045.06
								-2.0000		(\$1,045.06
WIP Receipt	D350-636-047 / Training Wearplates Installation, LH/RH	Main Warehouse	65910	FAUT01		0.0000		0.0000		
		FG062			2/16/2011	2.0000	65910	2.0000		\$1,045.06
								2.0000		\$1,045.06

65910 DISASSEMBLED
on 67916

